

Work Order ID 52762

October 14, 2009 9:08:01 AM



Page 1

Item ID: D3953-15

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Bracket

Start Date: 14/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: PL

Date: 09-10-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3953	A								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3953

Dwg Rev: 1

Prog Rev: 1

2-Deburr if necessary

IB 9-10-22

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-10-22

09/10/26 (14)

Work Order ID 52762

October 14, 2009 9:08:01 AM



Page 2

Item ID: D3953-15

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Bracket

Start Date: 14/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
130		0.00							
Small Fab	Memo	0.00							
Small Fab	1- CHAMFER HOLE AS PER DWG								
	2- DEBURR IF NECESSARY								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

⇒ S 09/10/26

(14)

S 09/10/27 (14)

⇒ S 09/10/27

(14)

Work Order ID 52762

October 14, 2009 9:08:01 AM



Page 3

Item ID: D3953-15

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Setup Start



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Stop



Item Name: Gas Spring Bracket

Start Date: 14/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
160	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

09/10/28 (14)

09/10/29 HJ
09-10-28

Picklist Print

October 14, 2009 9:08:08 AM

Page 1

Work Order ID: 52762



Parent Item: D3953-15



Parent Item Name: Gas Spring Bracket



Start Date: 14/10/2009

Required Date: 21/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	128.1312	0.1244	2000		
												
304/316 0.125 Sheet											139-10-02	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

128.1311979

111018

0.13119789

112663

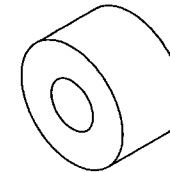
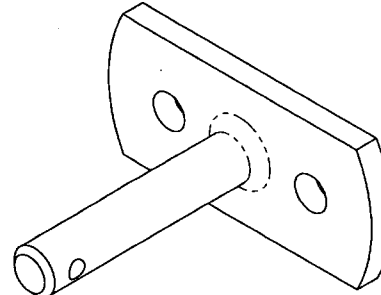
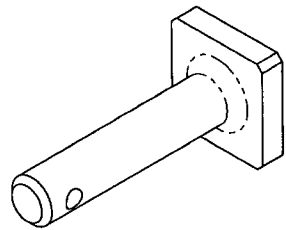
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WORK ORDER

NO. 52762
PL 09-10-14



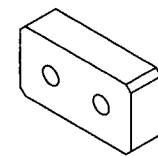
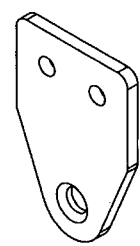
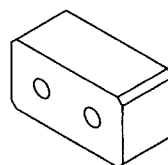
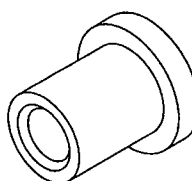
D3953-1 GAS SPRING BRACKET
 (FULL LID)

D3953-3 GAS SPRING STUD, LID

D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER
 (FULL LID)

D3953-15 GAS SPRING BRACKET
 (SPLIT LID)

D3953-17 GAS SPRING SPACER
 (SPLIT LID)

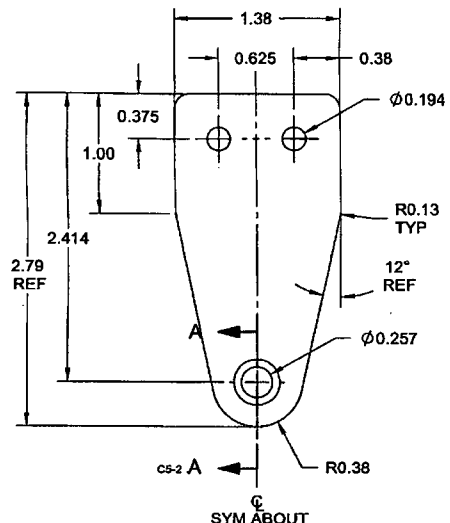
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 2009 -10- 08

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CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>[Signature]</u>	D3953	SHEET 1 OF 4
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	GAS SPRING LID COMPONENTS	NTS
DATE	09.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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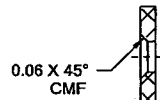
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WORK ORDER
NO. 52762

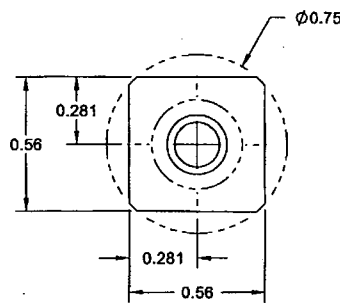
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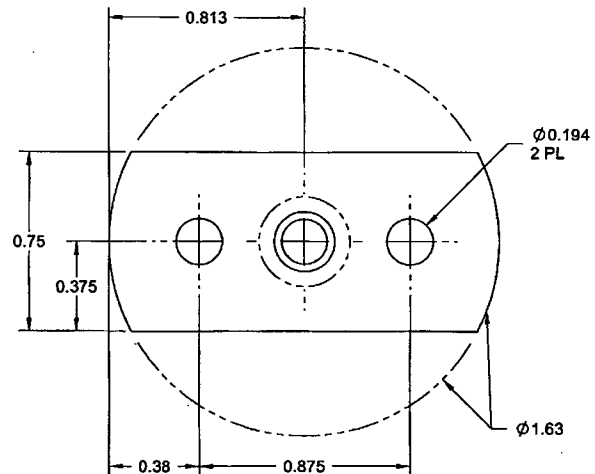
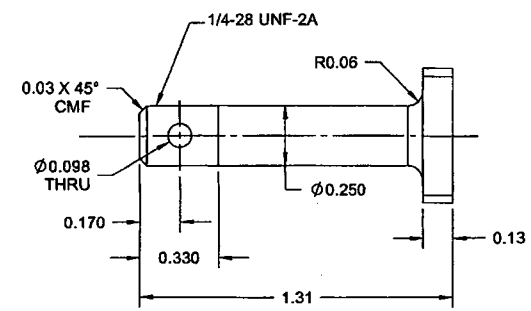
D3953-1 GAS SPRING BRACKET
(FULL LID)



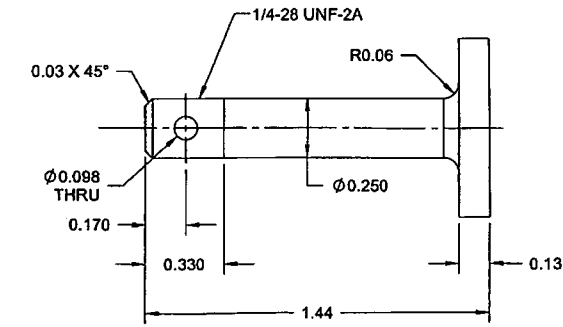
SECTION A-A C7-2



D3953-3 GAS SPRING STUD, LID



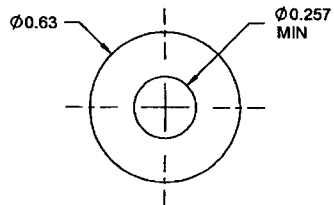
D3953-5 GAS SPRING STUD, BASE



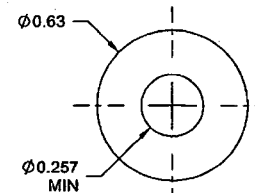
- NOTES:**
- 1) MATERIAL -1: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S
 - 3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
 - OR: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT -1: 0.11 lbs
-3: 0.03 lbs
-5: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	AJS	DRAWING NO. D3953	REV. A
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE GAS SPRING LID COMPONENTS	SCALE NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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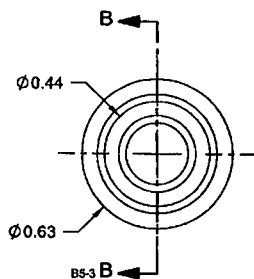
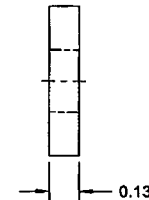
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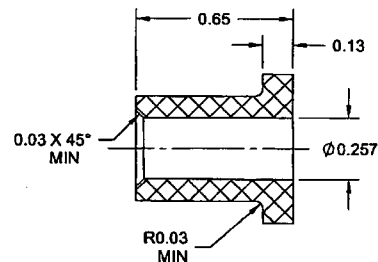
D3953-7 GAS SPRING SPACER



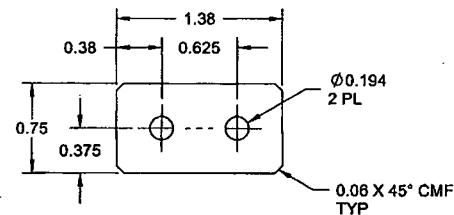
D3953-9 GAS SPRING WASHER



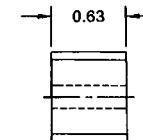
D3953-11 GAS SPRING SPACER



SECTION B-B B7-3



D3953-13 GAS SPRING SPACER



NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

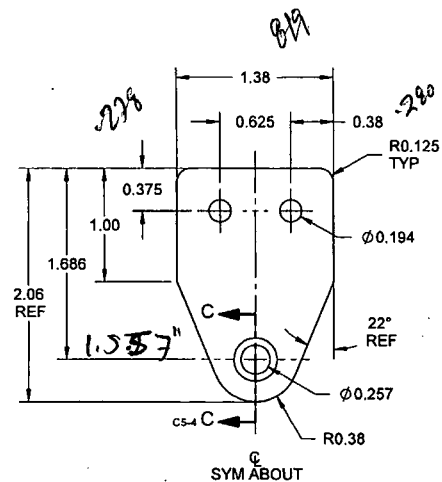
6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

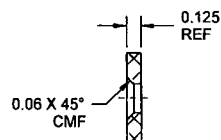
-13: 0.17 lbs

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2009-10-08

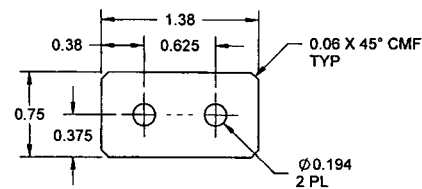
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DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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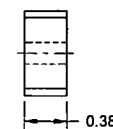
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



SECTION C-C C7-4



D3953-17 GAS SPRING SPACER
(SPLIT LID)



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2009-10-08
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NOTES:

1) MATERIAL -15: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 4 OF 4
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